



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBW6405G11931-3G

Job Sheet 199894



Part No: RBW6405G11931-3G

Job Qty: 1 pcs

Part Name: Tail Rotor Slider Bushing Removal & Replace



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/4/19

Job Tracking No:

Due Date: 11/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 19188

Note: DWG RBW6405G11931-3G Rev.1 IPP Rev. A 19.01.09 New issue DP Verify DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
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Container No: S234797



Part: RBW6405G11931-3G

Job No: 199894

Serial No/Batch: S234797

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 11/28/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	11/1/19		0.00	1.00	Small Fab - 1		MK
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	1 pcs	11/1/19		0.00	0.00	QC 5 - 10		DAS NOV 26 2019 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
120	Packaging 3-1 - Stock - B4B	1 pcs	11/1/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
130	QC 21 - FG	1 pcs	11/1/19		0.00	0.00	QC 21 - FG - 21		DAS 21 9-89 NOV 26 2019 NOV 26 2019
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 Descriptions: APP-1450-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
 RBW6405G11931-3G-7 to RBW6405G11931-3G-5 foam as per DWG. 6-Glue foam to case and pack case as per DWG.
 110 - QC5- Inspect part completeness to step on W/O
 120 - Identify as per dwg & Stock Location: _____
 130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet ✓	4 Ea (4 ea)	100-Small Fab - 1	2022TS 516393 4
APP-1450-E	Case RB007	1 Ea (1 ea)	100-Small Fab - 1	5218163
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	100-Small Fab - 1	021040
RBW6405G11931-3G-3	Bottom Foam 007	1 (1 ea)	100-Small Fab - 1	5218160
RBW6405G11931-3G-5	Lid Foam 007	1 (1 ea)	100-Small Fab - 1	5218162
RBW6405G11931-3G-7	Placard 98	1 pcs (1 ea)	100-Small Fab - 1	5214418
RBW6405G12031-3G	Tool, Tail Rotor Slider Bushing Removal	1 pcs (1 ea)	100-Small Fab - 1	5233692
RBW6405G12131-3G	Tool, Tail Rotor Slider Bushing Install 92	1 pcs (1 ea)	100-Small Fab - 1	5233089

01318

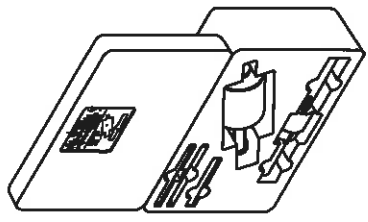
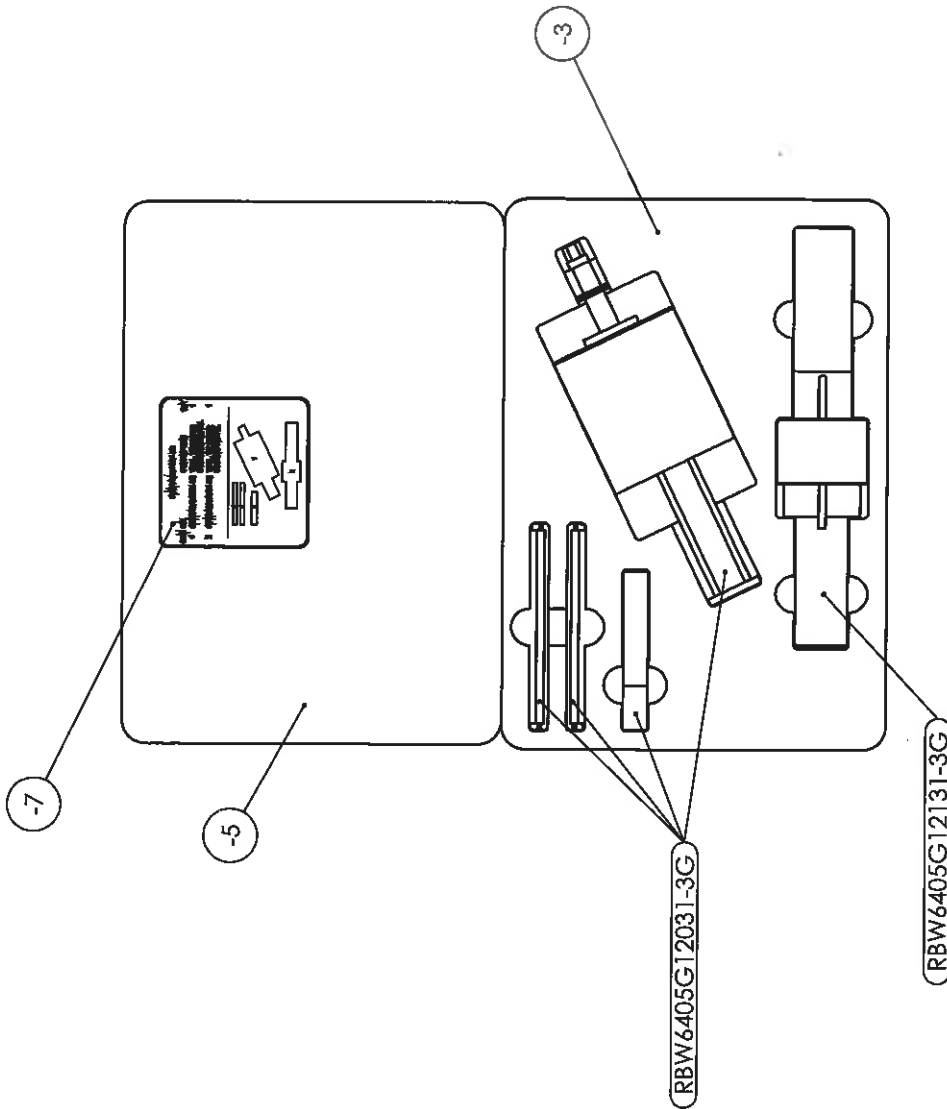
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	97524A032	4	221	0
	APP-1450-E	1	13	0
	RB41011	1	250	0
	RBW6405G11931-3G-3	1	0	0
	RBW6405G11931-3G-5	1	0	0
	RBW6405G11931-3G-7	1	0	0
	RBW6405G12031-3G	1	0	0
	RBW6405G12131-3G	1	0	0
Part Specifications				
Specifications could not be found.				

Plex 9/4/19 11:12 AM Dart.lajeunesse.marie

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REV	ECR	DESCRIPTION	REVISIONS
1		RELEASED FOR PRODUCTION.	

DATE	INITIAL	APPROVED
1/21/2016	DPD	JAG



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WITH NO
WORK IN PROGRESS
NO. 199894 MJS
19-09-04

NOTE:
REF. AGUSTA T/N: 3G6405G11931.

TITLE				T/R SLIDER BUSHING R&R (NEW STYLE BUSHING)				REV			
DWG NO.				RBW6405G11931-3G				1			
MATERIAL				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS 1/8 DECIMALS .005 ANGLES .5° SURFACES ±.125				1			
FINISH				1. BREAK ALL SHARP EDGES .015 X 45° OR .015R				2. DIMENSIONAL LIMITS APPLY PER DATUMS AND TOL PER ASME Y14.5M-2009			
SPEC				DRAWN BY: CLOUGH				CHECKED: DUERFELDT			
DPPS APPR:				3. INTERPRETING AND TOL PER ASME Y14.5M-2009				QA APPR: ANDERSON			
APPROVED:				SCALE 1:5				DATE 8/24/2015			
GILBERT				USED ON MODEL				SHEET 1 OF 4			

ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			1	TOOL, T/R SLIDER BUSHING REMOVAL (NEW STYLE BUSHING)		RBW6405G12031-3G	1
			1	TOOL, T/R SLIDER BUSHING INSTALL (NEW STYLE BUSHING)		RBW6405G12131-3G	1
	B/O	-1	1	CASE	PLASTIC	PELICAN CASE #APP-1450-E	N/S
	B/O	-3	1	BOTTOM FOAM	Y20 BLACK	4.29 X 10.40 X 14.94 (I.R. SPECIALTY)	2
	B/O	-5	1	LID FOAM	Y20 BLACK	1.79 X 10.28 X 14.69 (I.R. SPECIALTY)	3
		-7	1	PLACARD	PLASTIC		4
	B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	DEPARTMENT/PROCESS	Sequence #: _____ QTY Affected : _____ Disposition _____	MRB (QS1042)								
Date : _____		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____										
Description Work Order Deviation _____		FAULT CATEGORY <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 25%;"> Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ </td> <td style="width: 25%;"> Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ </td> <td style="width: 25%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ </td> <td style="width: 25%;"> Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐ </td> </tr> </table>			Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				
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Root Cause <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 25%;">Operator ☐</td> <td style="width: 25%;">Manufacturing Process ☐</td> <td style="width: 25%;">Equip/Tooling ☐</td> <td style="width: 25%;">Handling/Preservation ☐</td> </tr> <tr> <td>Material ☐</td> <td>Product Improvement ☐</td> <td>Process Improvement ☐</td> <td>Human Factors ☐</td> </tr> </table>		Operator ☐	Manufacturing Process ☐	Equip/Tooling ☐	Handling/Preservation ☐	Material ☐	Product Improvement ☐	Process Improvement ☐	Human Factors ☐			
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